

Date: Thursday, 08/05/2008 12:00:03 PM  
User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SADDLE SPACER		
Job Number	: 39125			Part Number	: D2877		
Estimate Number	: 10827			Drawing Number	: D2877 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 08/05/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 20/05/2008 Qty: 120 Um: Each		
Previous Run	: 36276						
Written By	:						
Checked & Approved By	: JWL 08.5.08						
Comment	: Est B 00.05.19 Added inspect level 8 EC Est C 06.04.26 Water jet EC Est Rev:D Now M6061-T6 06-06-23 JLM Est Rev:E Updated Thickness as per Rev B 06-09-18 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet  Comment: Qty.: 0.0637 sf(s)/Unit Total : 7.6482 sf(s) Material: 6061-T6 (QQ-A-250/8) 0.125" Thick Batch: 106634 HB 8-5-8
2.0	WATER JET	FLOW WATER JET  Comment: FLOW WATER JET 1-Cut as per Dwg D2877 Dwg Rev: B HB 8-5-8 Prog Rev: B (B6)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  HB 8-5-8
4.0	QC8	SECOND CHECK  Comment: SECOND CHECK 5/08/12 (4/35)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary EB08/05/12 (135)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2877 PAR #: N/A Fault Category: Prod/Fab Ass <sup>Med & Small</sup> NCR: Yes No DQA: D Date: 08/05/14  
 QA: N/C Closed: D Date: 08/05/15

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/12	# 2.0	one part scrap. water jet cut a notch out of one of the Ø.257 holes R.C.: Machine Malfunction	D S/11/12	Scrap and Destroy No Replace Qty (x1)	B 8-5-12	C 08/05/12	J 10/11/12	C 08/05/12

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(135)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W/F 08/05/12

08/05/12

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

R. Joffre (130)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08.05.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39125
Description: Saddle Spacer	Part Number:	D2877
Inspection Dwg: D2877	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>BS</u>	Audited by:	<u> </u>	Prototype Approval:	N/A
Date:	8-5-8	Date:	08/05/12	Date:	N/A

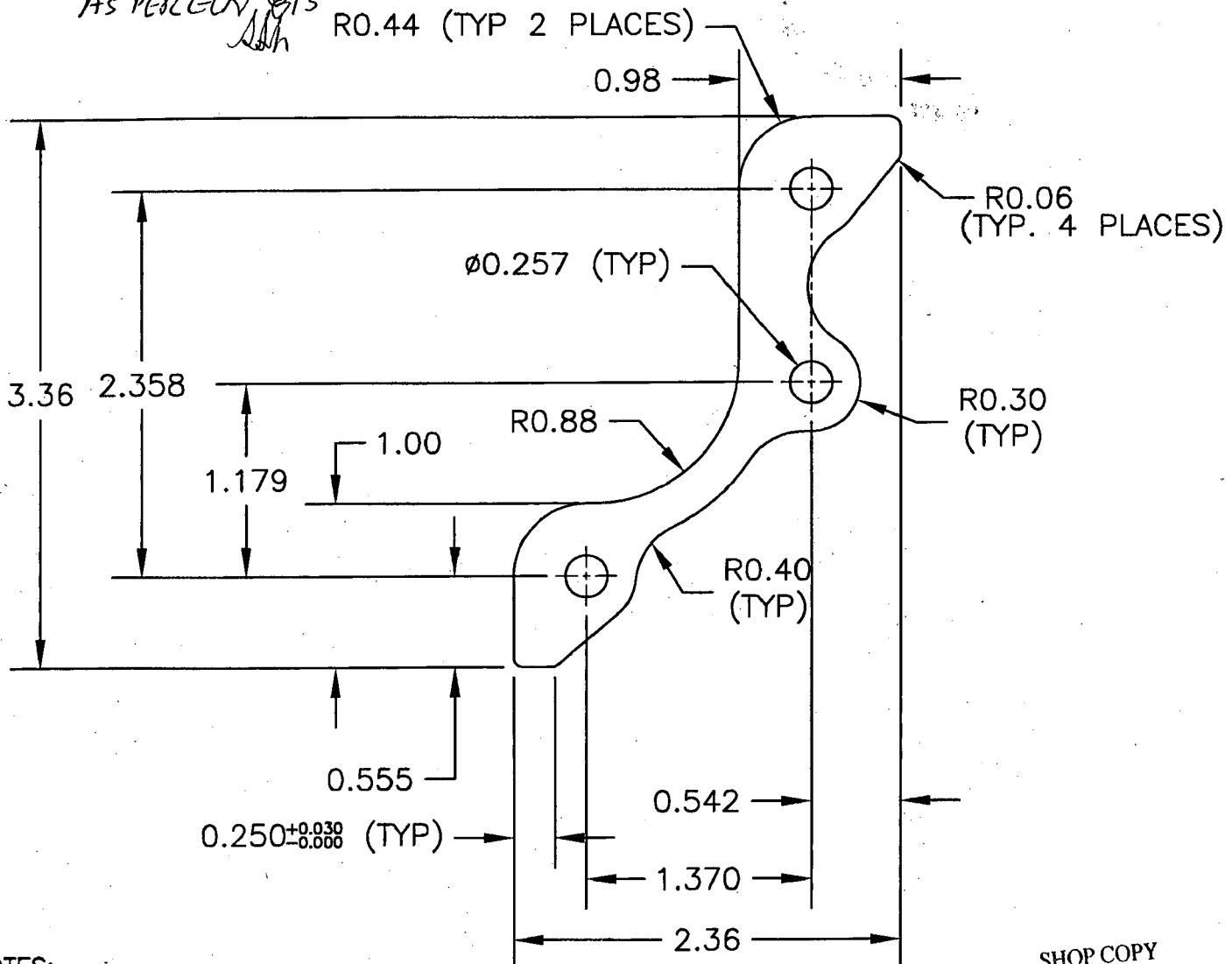
Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D2877	REV. B SHEET 1 OF 1
DATE 06.05.17		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.05.17	THICKNESS WAS 0.100", MAT CHANGE	

**RELEASED**

(06.06.21)

AS PER ECON 813  
*MM***NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK  
(REF DART SPEC M6061T6S.125)  
OR  
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK  
(REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39125

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